

Date: Wednesday, 10/12/2008 7:51:59 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 3" SKID EXTRUSION (NO OUTER RIDGE)
<b>Job Number</b> : 43960	
<b>Estimate Number</b> : 10054	
<b>P.O. Number</b> :	<b>Part Number</b> : D26003120
<b>This Issue</b> : 10/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2600 REV D1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : D1
<b>Previous Run</b> : 37756	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 31/12/2008 <b>Qty:</b> <u>69</u> <b>Um:</b> <u>100</u> <b>Each</b>
<b>Checked &amp; Approved By</b> : <u>C20812/10</u>	
<b>Comment</b> : Est. D: 02.09.10 Added DSK 066 KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 7802

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long
- g) Bon L Canada Inc. tool # 897122
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

C20812/10100 69

2.0

D26003120P

Extrusion Round 3" 350



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)  
 Extrusion Round 3" 350

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
 Ensure material certification is attached

C 9/01/1379

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimension per Dwg D2600  
 Check Pull test per Dwg D2600 for compliance page attached  
 Check hardness with Webster tester

509601/1479

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/12/2008 7:51:59 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 43960

Part Number: D26003120

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

HALL 008 → 48 HALL 007 → 31 09/01/15 (79) dm

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/16 JH

Job Completion



MF  
09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>FGP</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

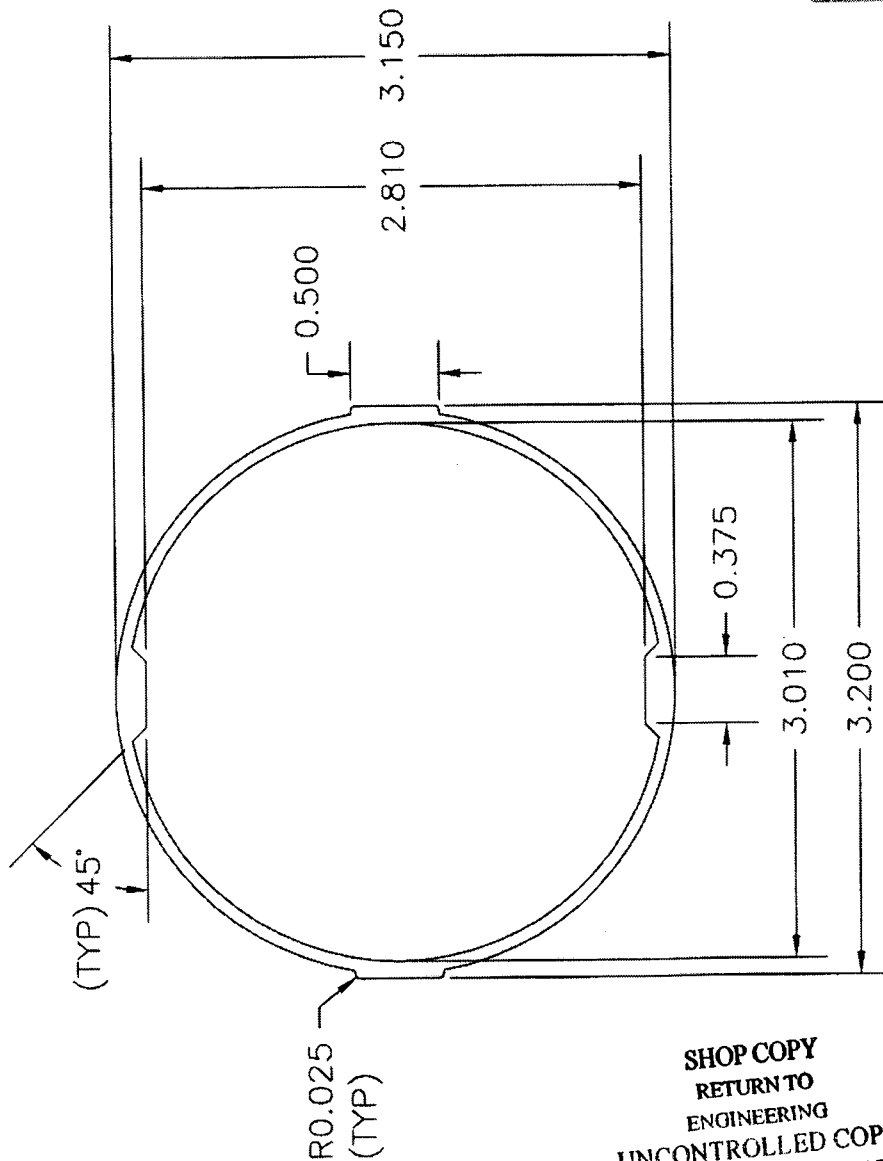
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. B43960



DESIGN <i>DB</i>	DRAWN BY <i>DB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DB</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



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WORK ORDER  
NO. B43960

D2600-1

MANUFACTURED WITH CARADON INDALOX DIE # MH-18870

OR BOW L DIE # 897121 (PREFERRED CHOICE)

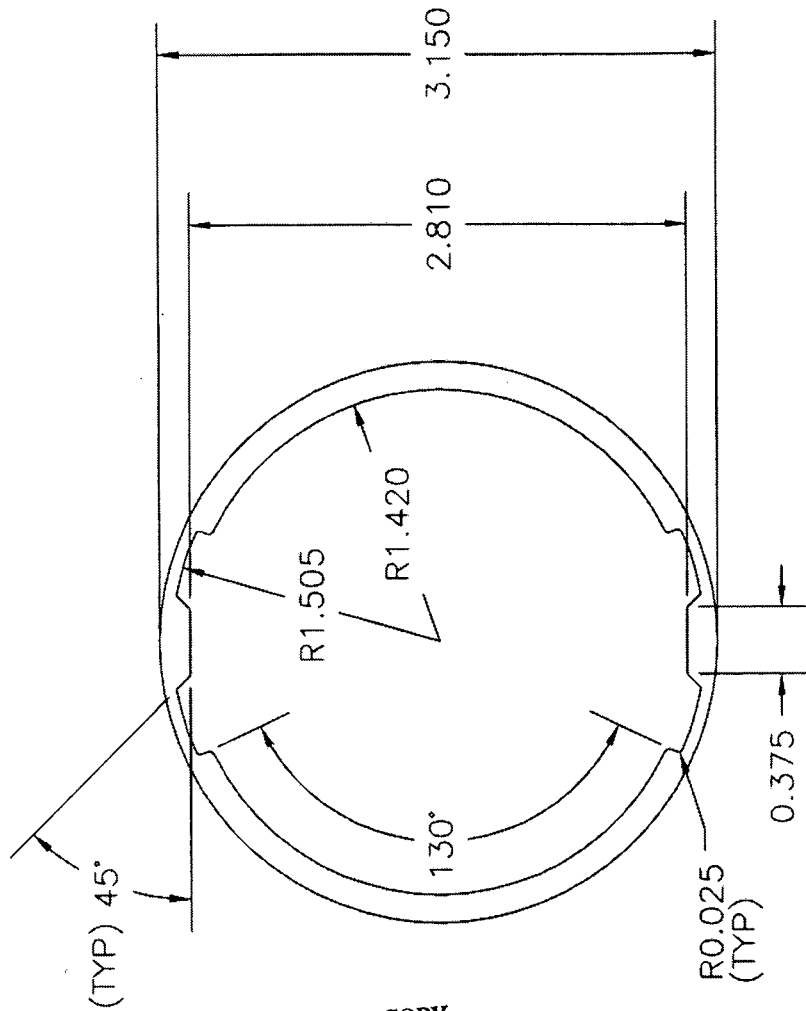
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



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WORK ORDER  
NO. B93960

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

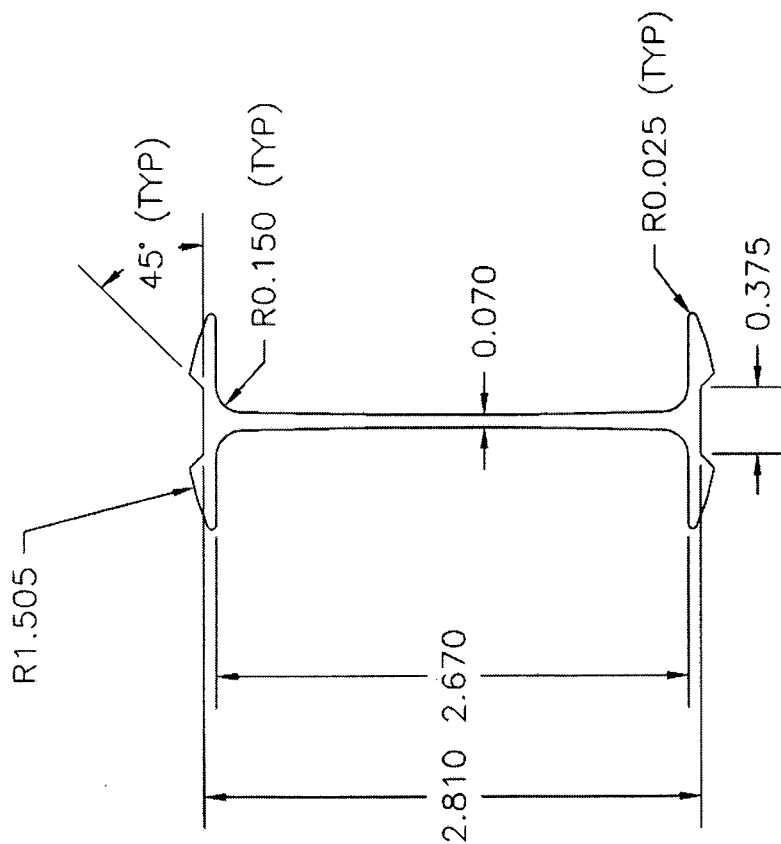
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (E.G. D2600-3-170 IS 170" LONG)





DESIGN <i>MB</i>	DRAWN BY <i>MB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



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WITHOUT NOTICE  
WORK ORDER  
NO. B 43960

D2600-5  
MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

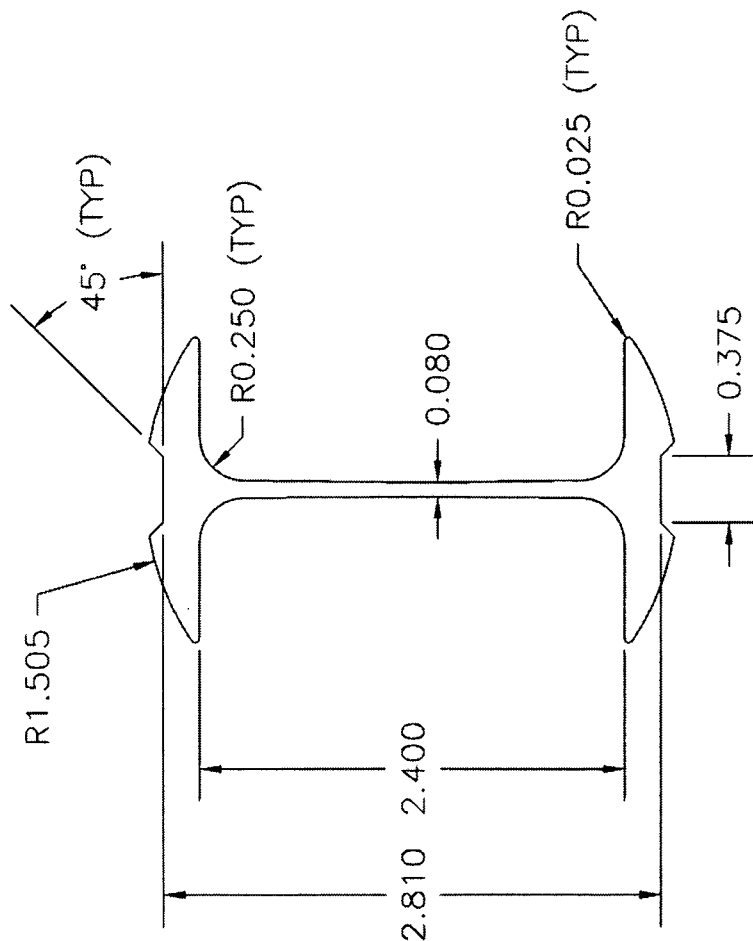






DESIGN <i>RR</i>	DRAWN BY <i>RR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98 8 25 DS



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WITHOUT NOTICE  
WORK ORDER  
NO. B 43960

D2600-7  
MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)





ACCT# 00046024

INVOICING COMPANY AND LOCATION  
SIGNATURE ALUMINUM CANADA  
1850 CLEMENTS ROAD  
PICKERING ON L1W 3R8

## SHIPPING MANIFEST

MANIFEST DATE
01-12-09
MANIFEST NUMBER
653104
SALES ORDER NUMBER
41303

REFER TO  
THESE NUMBERS ON  
ALL CORRESPONDENCECREDIT REP  
HAMBROOK, PAU  
905-508-3250

SALES REP

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
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TERMS / FREIGHT

O / P

CUSTOMER ID 46024	ORDER DATE 12/11/08	CUSTOMER PO NUMBER 7802	JOB	BILL OF LADING NUMBER 08387492
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	69	KG	0	DAA-897122-1	6061 /T6	MILL	2	582	564	KG	0
		M	0	D2600-3-120	120"	CERTIFICATE OF COMP			240.79	M	0
		PC	0		+3/16 "	(+015-015,0079-0058)			79	PC	0
					-0 "						
		LOT/TKT DETAIL:					41303010 / 299317	1	338	329	
						41303010 / 299318	1	244	235		33 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.

No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE

1

2	582	564	KG
		240.79	M
		79	PC
TOTALS			

# CERTIFICATE OF COMPLIANCE

## SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
01/12/09	185970	41303	1
Cust. PO	B/L No.	Lot	Date
7802	08387492	41303010	1/12/09

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust. Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	582 KGS		
Net Qty	564 KG	79 PC	241 M 2 PKG
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	306.7 / 44.5	273.1 / 39.6	13.3	.0	94

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.66	.28	.27	.08	.90	.06	.09	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

S  
09/01/14

*Conchita Ko.*